

Date: Tuesday, 08/07/2008 9:18:37 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 40359	
Estimate Number : 12900	
P.O. Number :	Part Number : D35089
This Issue : 08/07/2008 S.O. No. :	Drawing Number : D3508 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 36417	Material :
Written By :	Due Date : 30/08/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.7.08</u>	
Comment : Est Rev:A New Issue 07.06.12 EC	
Est Rev:B Rev C dwg 07-12-06 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.4379 sf(s)/Unit Total : 4.3785 sf(s)
 304 SS .038" THK (20GA)
 (M304S20GA)
 Batch: 108156 HB 8-7-07

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: C
 Prog Rev: C

HB 8-7-17

2-Deburr if necessary

HB 8-7-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEHB 8-7-17

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKSB 08/07/17 (+10)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

SB 08/07/17(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 9:18:37 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 40359

Part Number: D35089

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



M1106442



Comment: INSPECT WORK TO CURRENT STEP

8086717240

7.0

POWDER COATING

POWDER COATING



(11x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40 =
320 °F
12:10

M. 08/07/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(11)

Comment: INSPECT POWDER COAT

Ed 08/07/21

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: EP21

M. 08/07/21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

Dart Aerospace Ltd

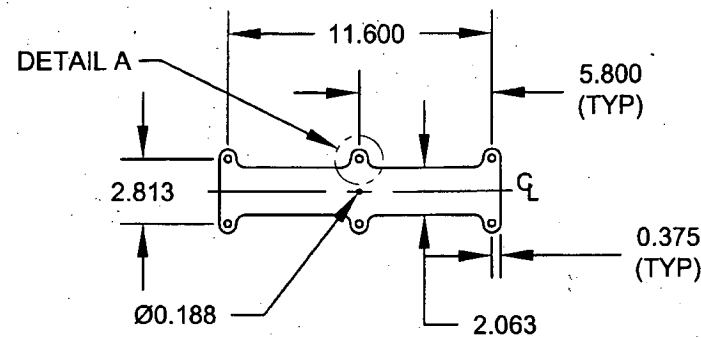
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

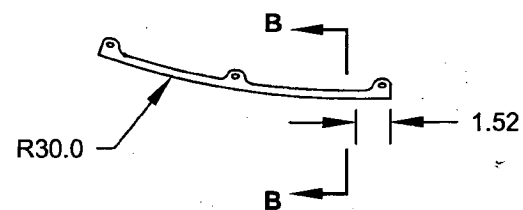
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

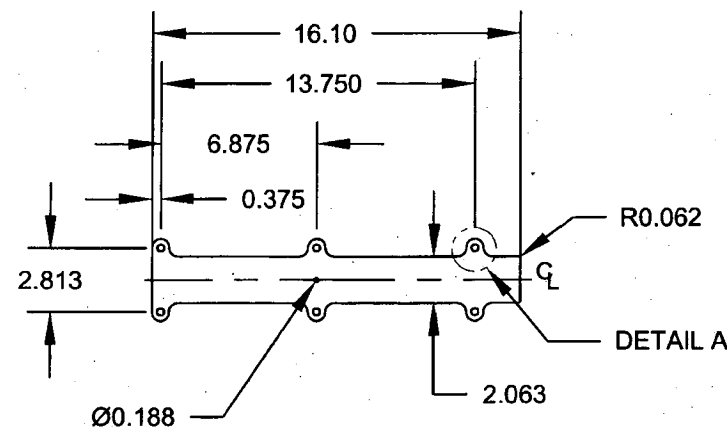
NOTE: Date & initial all entries



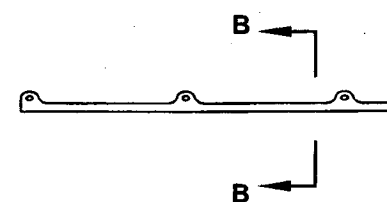
D3508-1 FLAT PATTERN



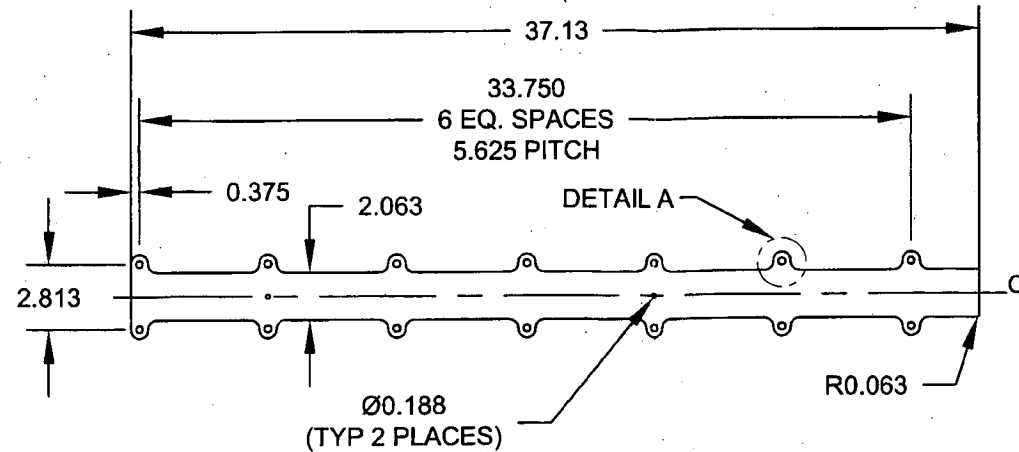
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



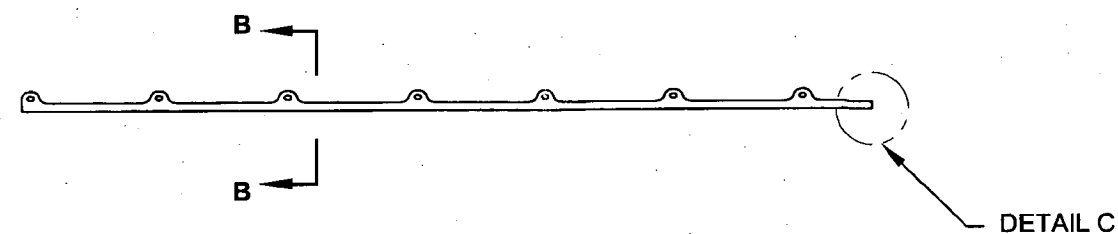
D3508-7F FLAT PATTERN



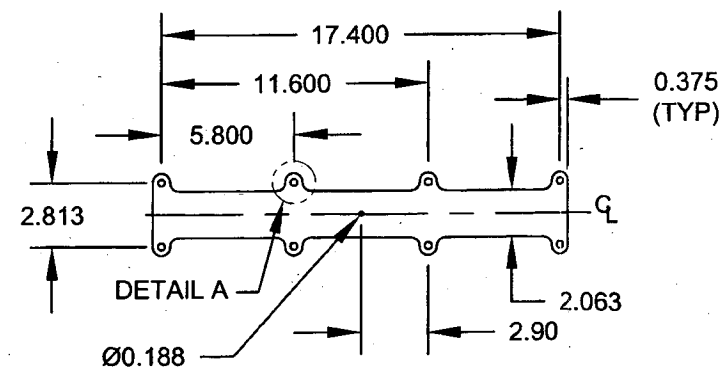
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



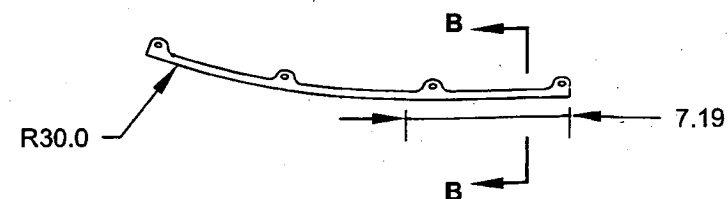
D3508-3 FLAT PATTERN



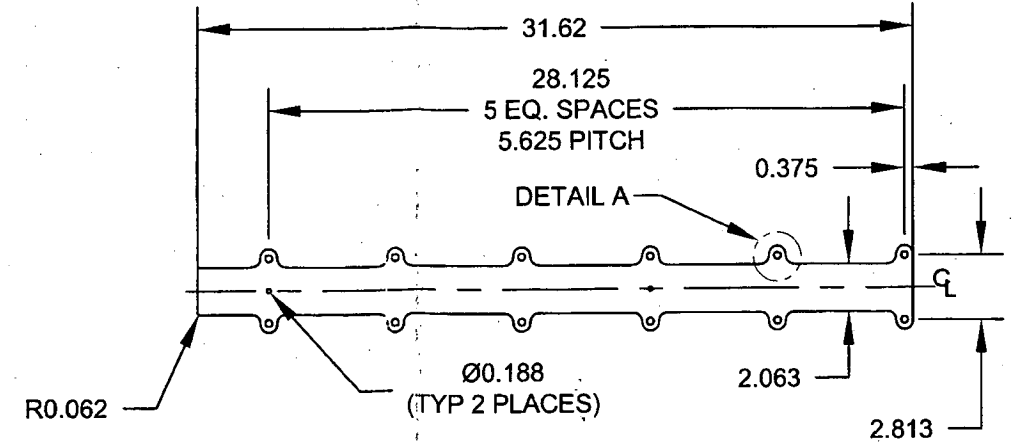
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



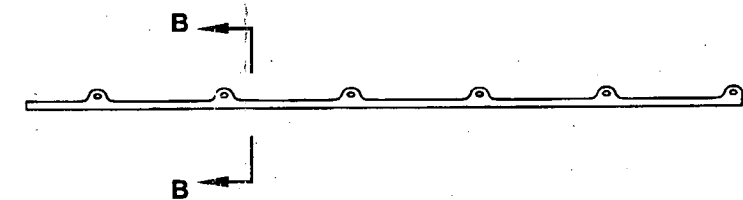
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



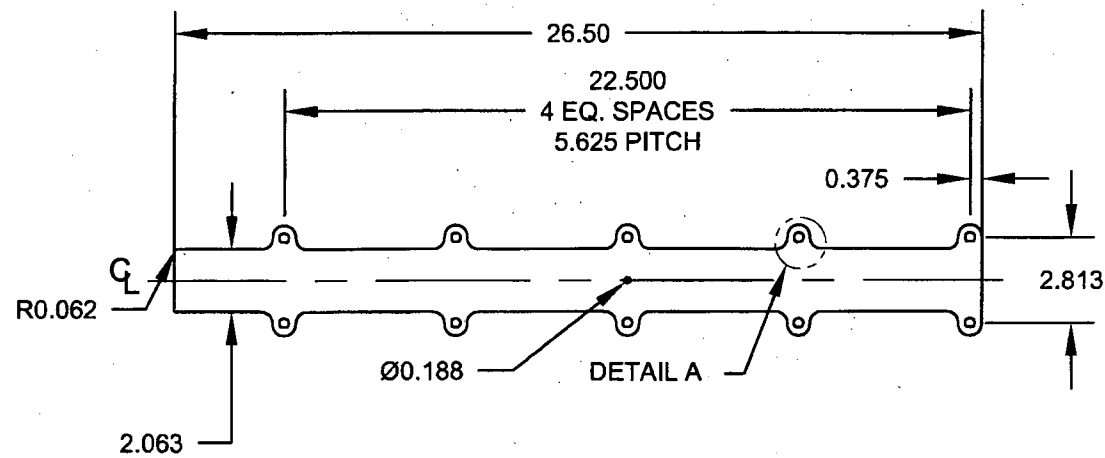
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

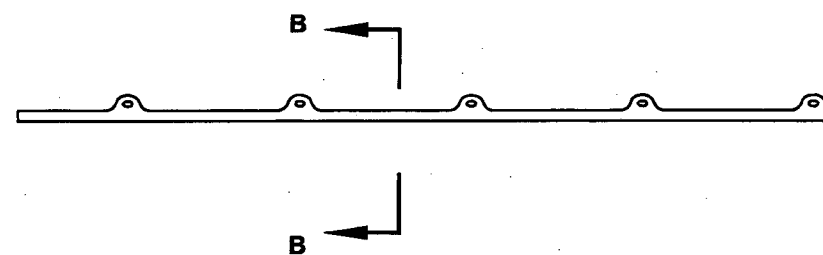
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07.11.16
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40359

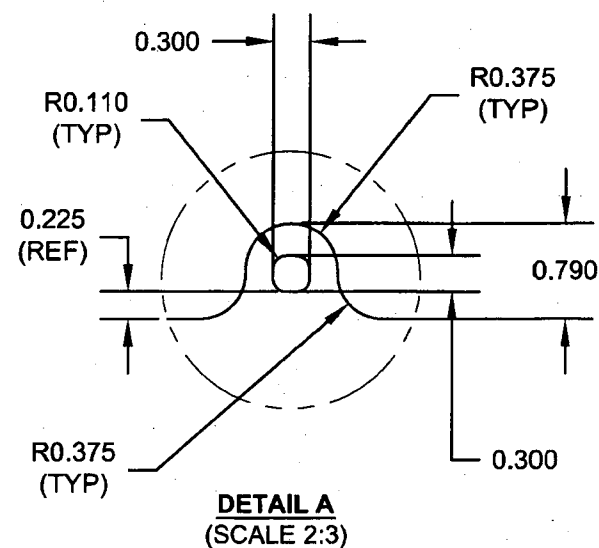
C	ADD -9/11/13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3508	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



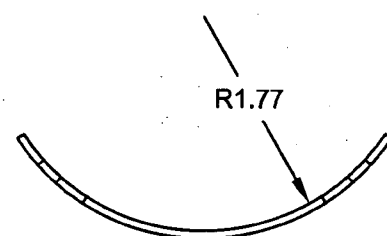
D3508-11F FLAT PATTERN



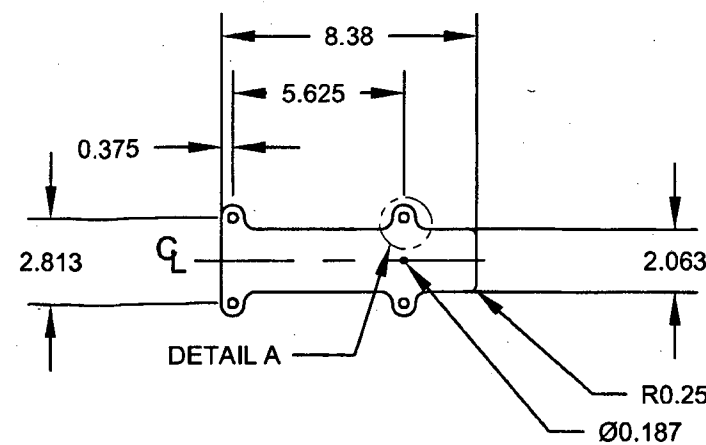
**D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)**



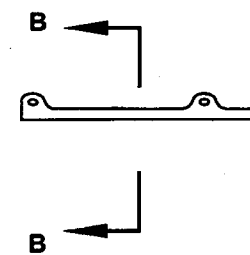
**DETAIL A
(SCALE 2:3)**



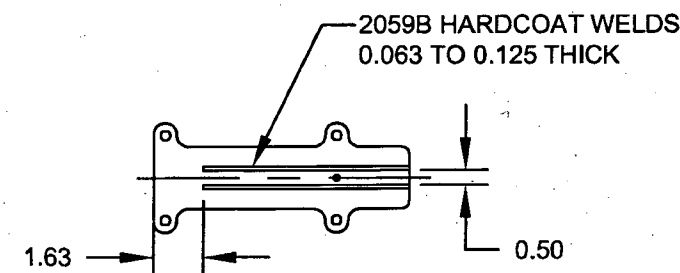
**SECTION B-B
(SCALE 2:3)**



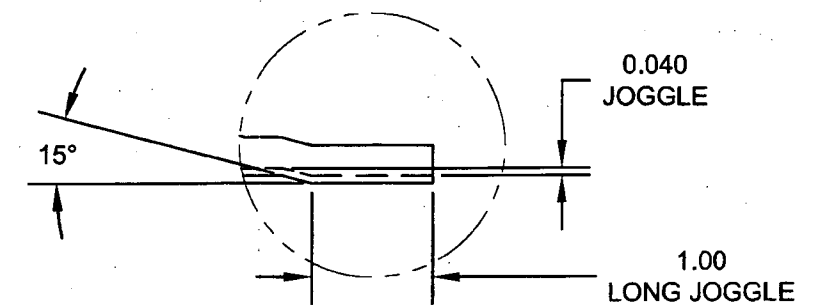
D3508-13F FLAT PATTERN



**D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)**



D3508-13 WELDING DETAIL



**DETAIL C
(SCALE 1:2)**

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WORK ORDER
NO. 40359

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07.11.16

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DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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